

Work Order ID 53351-1

November 2, 2009 10:42:15 AM

Blue



SPLIT-1

Page 1

Item ID: D3407-043

Accept



Setup Start



Revision ID: E

Item Name: Tow Ring

Stop



Start Date: 02/11/2009 Start Qty: <sup>16</sup>~~20.00~~



Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

*[Signature]*

Date:

09/11/2

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3407	Rev E								

100



Large Fab

Large Fab

Large Fab

0.00

Memo

0.00

Weld D3407-3/-5 using welding rod TIG174 as per Dwg D3407 & QSI  
004 A/R TIG174 ROD Batch: *M101972*

*Cpl 09 11 09*

110



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Memo

0.00

*D 09.11.10 25*

120



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

*2e 09.11.10*



**Work Order ID 53351**

November 2, 2009 10:42:15 AM



Page 2

Item ID: D3407-043

Revision ID: E

Item Name: Tow Ring

Start Date: 02/11/2009 Start Qty: 20.00

Required Date: 13/11/2009 Req'd Qty: 20.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Run Start



Stop



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

125

SprayPaint  
Spray Painting

Spray Painting per QSI005 4.2

0.00

Memo

0.00

Prime B 110918  
Spray Paintat Delfleet Blue B 113171  
Clear Delfleet B 113088

135

QC  
Quality Control

QC14- Inspect Spray Paint

0.00

Memo

0.00

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00

150

Packaging  
Packaging

Memo

0.00

ml 09 11 2409-11-25 1011/11/30 16





Work Order ID 53351

November 2, 2009 10:42:15 AM



Duplicate of P3

Page 3

Item ID: D3407-043

Revision ID: E

Item Name: Tow Ring

Start Date: 02/11/2009 Start Qty: 20.00

Required Date: 13/11/2009 Req'd Qty: 20.00

Reference:

Approvals:

QC: Date: Tooling: SPC (Y/N):

Sequence ID/ Work Center ID

Operation Description

QC 21 - Final Inspection - Work Order Release

QC: 0.00

Quality Control

0.00

0.00

0.00

0.00

0.00

0.00

0.00

0.00

0.00

0.00

0.00

0.00

0.00

0.00

0.00



# Picklist Print

November 2, 2009 10:42:21 AM

Page 1

Work Order ID: 53351



Parent Item: D3407-043RevE



Parent Item Name: Tow Ring

Start Date: 02/11/2009

Required Date: 13/11/2009

Comments:

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3407-3RevE 		Manufactured	No			100	Each	0.0000	20.0000			
Stem D3407-5RevE 		Manufactured	No			100	Each	31.0000	20.0000			
Ring												

✓  
B53350 → 20 Cpl 09/11  
Cpl 09-11-09

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA

31

51633

10

52318

21

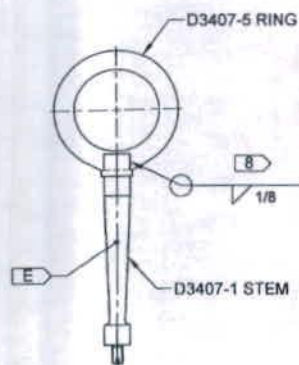
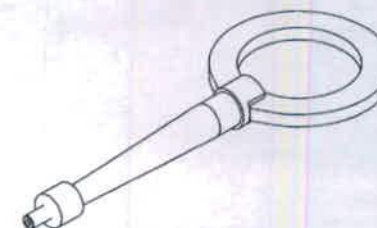
10 ✓  
10 ✓



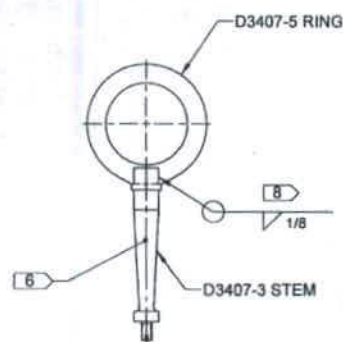


QTY -041	QTY -043	QTY -045	PART NUMBER	DESCRIPTION
X			D3407-041	TOW RING
	X		D3407-043	TOW RING
		X	D3407-045	TOW RING
1			D3407-1	STEM
	1		D3407-3	STEM
1	1	1	D3407-5	RING
		1	D3407-7	STEM

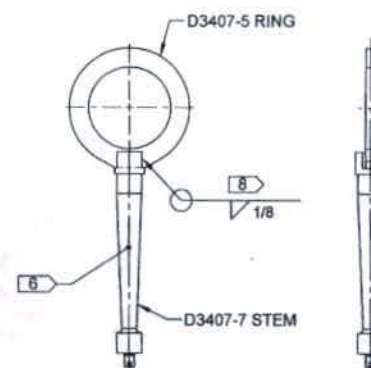
STANDARD  
REVISION  
UNCONTROLLED  
SUBJECT TO  
WITHDRAWAL  
WORK CENTER  
NO. 53351  
BH 09-11-2



D3407-041 TOW RING



D3407-043 TOW RING



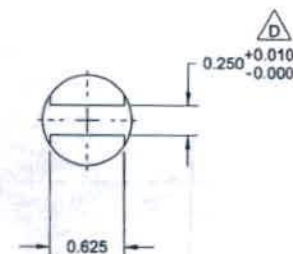
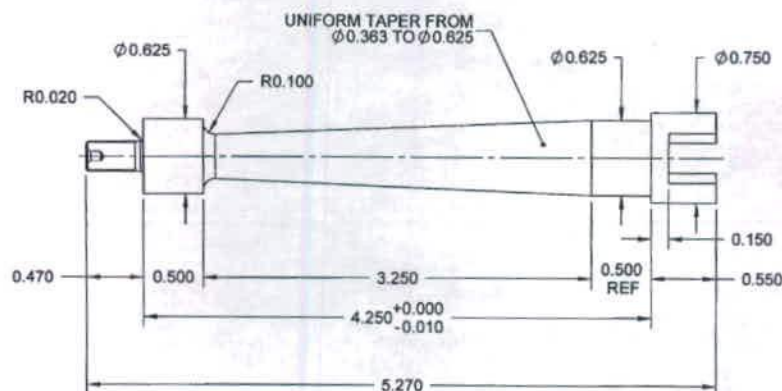
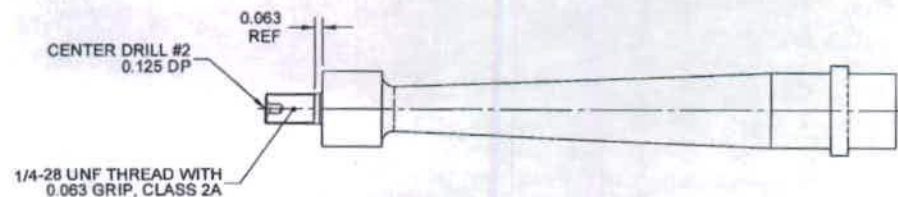
D3407-045 TOW RING

RELEASED  
05-08-01

- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3 (EXCEPT THREADS)
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3407-XXX" USING BLACK FINE POINT PERMANENT INK MARKER
  - 7) WEIGHT: D3407-041 - 0.60 lbs, D3407-043 - 0.53 lbs, D3407-045 - 0.61 lbs
  - 8) WELD PER DART QSI 004 ON ALL EDGES BETWEEN STEM AND RING

E	ADD D3407-045 (ZN B2-1, D8-1); ADD D3407-7 (ZN B6-5); REVISED NOTE 8 TO ADD IDENTIFICATION (ZN A5-1); REASON: PRODUCTION FACILITY	PH	08.07.23
D	D3407-1/3 SLOT WAS ROUND NOW FLAT FOR ASSEMBLY WITH D3407-5 (ZN C2-2, C2-3); D3407-5 WAS ROUND NOW FLAT ON ONE END FOR ASSEMBLY WITH D3407-1/3 (ZN B6-4); REASON: PRODUCTION FACILITY	PH	08.04.07
C	-1/3 LONGER FOR FIT WWASHER	CP	05.09.09
B	UPDATE DIAMETER, THREAD CLASS ADDED	CP	05.06.17
A	NEW ISSUE	CP	05.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE USA, INC.	
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MFG. APPR.		D3407	SHEET 1 OF 6
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DE APPR.	TOW RING		NTS
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08.07.23			





**D3407-1 STEM**

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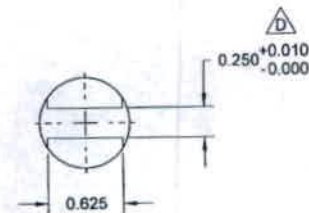
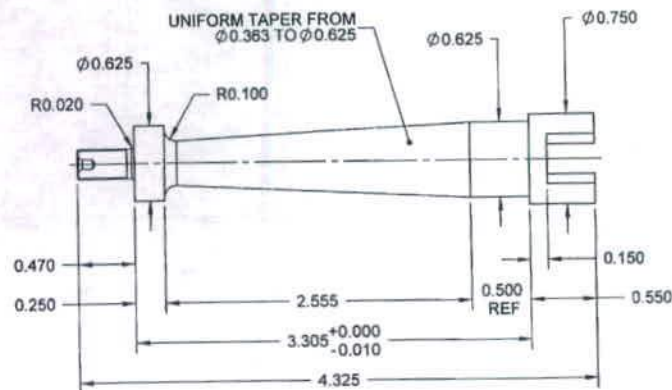
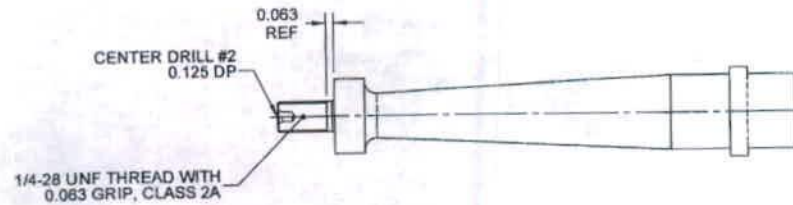
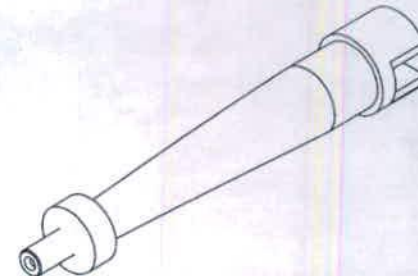
- NOTES:
- 1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.33 lbs

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D3407-3 STEM

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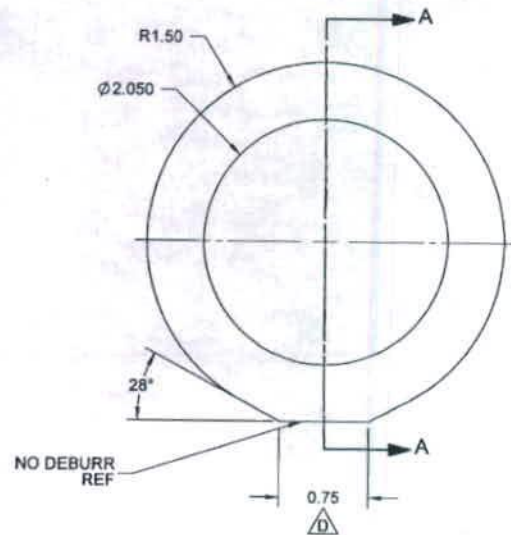
- NOTES:
- 1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.27 lbs

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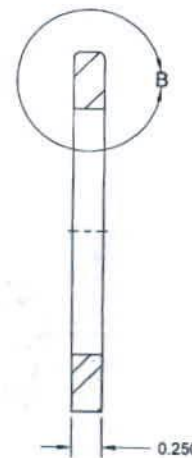




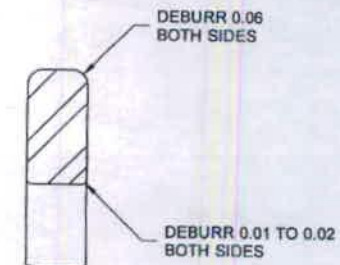
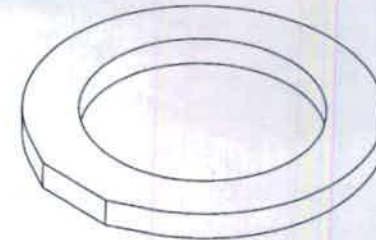
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**D3407-5 RING**



**SECTION A-A**



**DETAIL B  
SCALE 2X**

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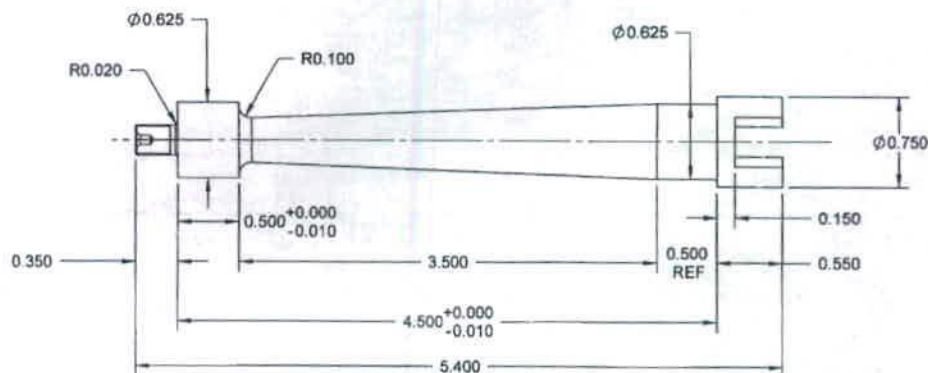
- NOTES:**  
1) MATERIAL: 17-4 PH SS BAR PER AMS 5604/5643 (REF. DART SPEC M17-4-B)  
2) FINISH: NONE  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: N/A  
6) IDENTIFICATION: N/A  
7) WEIGHT: 0.27 lbs

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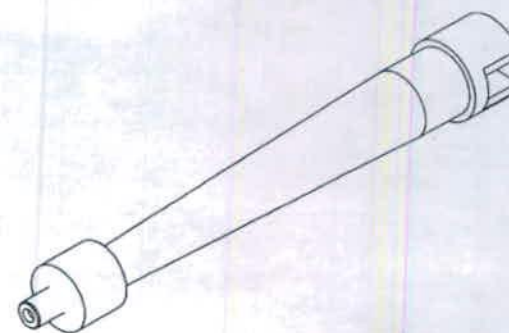
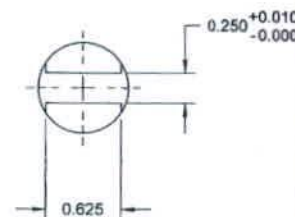


CENTER DRILL #2  
0.125 DP

1/4-28 UNF THREAD WITH  
0.063 GRIP, CLASS 2A



**D3407-7 STEM**



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06-09-01 NIP

- NOTES:
- 1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.34 lbs

DESIGN	AJS	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA	
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CHECKED		DRAWING NO.	REV. E
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